



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

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Fax 613 632-5246

D3282-041
Job Sheet 184269



Part No: D3282-041

Job Qty: 8 ea

Part Name: Float Web (206L/407)



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/4/18

Job Tracking No:

Due Date: 10/26/18

Created By: Jesse White

Type: Stock

Description:

Note: DWG REV D IPP Rev:B 05.09.23 Procedure change KJ/JLM IPP REV:C 11.09.20 remove LPS as per dwg revD DD verf:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	8 Ea	10/26/18	10/26/18	0.00	0.00	Start Up Skidtubes-1		DD
100	Skidtubes	8 pcs	10/26/18	10/26/18	0.00	1.33	Skidtubes-3		TF
110	CNC Vertical Machining	8 pcs	10/26/18	10/26/18	0.31	13.11	HAAS1-3		18/10/20
130	QC	8 pcs	10/26/18	10/26/18	0.00	0.00	QC8		18/10/30
140	HandFinish	8 pcs	10/26/18	10/26/18	0.00	1.86	HandFinish1		D.R. 18/10/30
150	QC	8 pcs	10/26/18	10/26/18	0.00	0.00	QC7-2		haha
160	Skidtubes	8 pcs	10/26/18	10/26/18	0.00	2.00	Skidtubes-3		DD
170	QC	8 pcs	10/26/18	10/26/18	0.00	0.00	QC5		DD
180	Packaging	8 pcs	10/26/18	10/26/18	0.00	0.00	Packaging3-1		DD
190	QC21-SA	8 Ea	10/26/18	10/26/18	0.00	0.00	QC21		DD

Part Op 100 - 1-Cut to length as per Dwg D3282. 2- inspect for surface damage as per QSI0018
Descriptions: 110 - 1-Machine as per Folio FA579 & Dwg D3282 2-Deburr
160 - 1-Install doublers as per Dwg D3282.
180 - LOCATION : LG002

DAS
21 NOV 10 7 2018
9-86

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2792-130	Extrusion	8 Ea (1 ea)	90-Start up Operation	128109
D3283-1	Doubler	16 Ea (2 ea)	160-Skidtubes	315x M1346 40 14x 5048900
MS20470AD4-7	Rivet, Universal Head	456 Ea (57 ea)	160-Skidtubes	10x B153513 7x S62298

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D2792-130	8	52	0
160-Skidtubes	D3283-1	16	43	0
	MS20470AD4-7	456	1,243	0

1270 Abercrombie Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 813 632-5200
Email: sales@dartheero.com
www.dartheerospace.com

Container No. S118224



Part: D3262-041

Job No: 184269

Serial No/Batch: S118224

Revision:

Inspector:

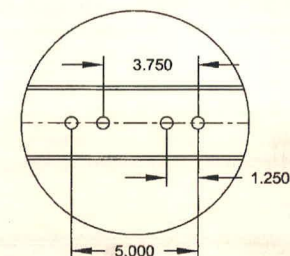
Exp Date:

Instructions: Various STC's

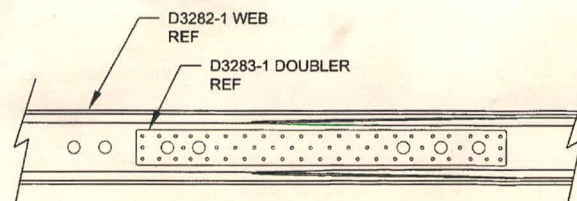
Date: 10/15/18

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Float Web	126.600inches $\pm$ 0.010	126.610 126.590		
2	Float Web	1.500inches $\pm$ 0.010	1.510 1.490		
3	Float Web	3.000inches $\pm$ 0.010	3.010 2.990		
4	Float Web	6.000inches $\pm$ 0.010	6.010 5.990		
5	Float Web	1.250inches $\pm$ 0.010	1.260 1.240		
6	Float Web	30.000inches $\pm$ 0.010	30.010 29.990		
7	Float Web	1.500inches $\pm$ 0.010	1.510 1.490		
8	Float Web	72.010inches $\pm$ 0.030	72.040 71.980		
9	Float Web	61.750inches $\pm$ 0.030	61.780 61.720		
10	Float Web	57.500inches $\pm$ 0.030	57.530 57.470		
11	Float Web	49.190inches $\pm$ 0.030	49.220 49.160		
12	Float Web	43.940inches $\pm$ 0.030	43.970 43.910		
13	Float Web	39.690inches $\pm$ 0.030	39.720 39.660		
14	Float Web	26.680inches $\pm$ 0.030	26.710 26.650		
15	Float Web	0.550inches $\pm$ 0.030	0.580 0.520		
16	Float Web	1.970inches $\pm$ 0.010	1.980 1.960		
17	Float Web	2.380inches $\pm$ 0.030	2.410 2.350		
18	Float Web	0.050inches $\pm$ 0.030	0.080 0.020		

Plex 10/4/18 11:55 AM dart.white.jesse



**NOTE: RIVET HOLES/DOUBLER
NOT SHOWN FOR CLARITY**

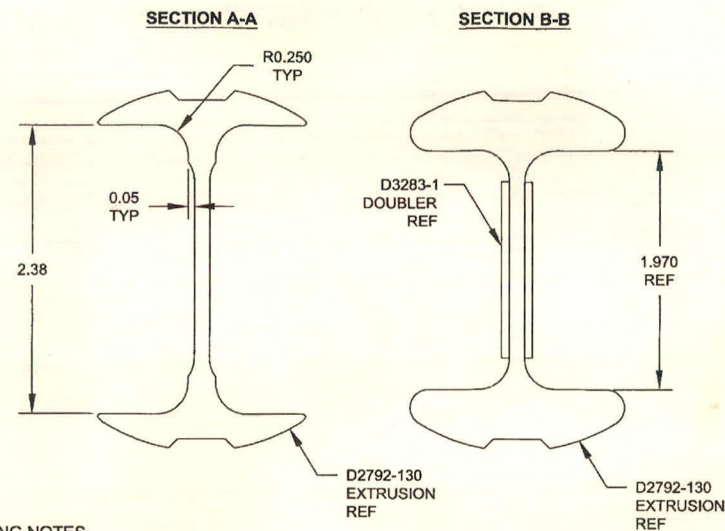


DETAIL D

NOTES:

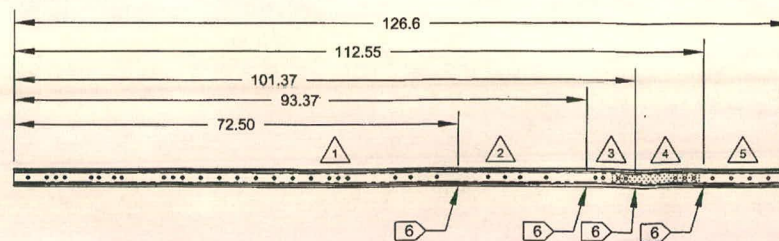
- 1) MAKE D3282-1 WEB FROM D2792-130 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 6) IDENTIFICATION: IDENTIFY WITH P/N "D3282-041" PER QSI 044 6.1 (FINE POINT PERMANENT INK MARKER)
- 7) WEIGHT: 20.0 lbs
- 8) SEE PAGE 2 FOR MACHINING DETAILS

C	ADD ADDITIONAL HOLE (ZN D6-1); REMOVE LPS-3 (ZN C3-1)	SC	11.05.05
D	REMOVE D3390-1, NOW MACHINED	CP	05.08.09
B	MOVE HOLES, ADD D3390-1 DOUBLERS	CP	05.03.16
A	NEW ISSUE	CP	04.05.05
REV.	DESCRIPTION	BY	DATE
DESIGN	CP	DART AEROSPACE USA, INC PORT HADLOCK, WA	
DRAWN	SC		
CHECKED	<i>qf</i>	DRAWING NO.	REV. D
MFG. APPR.	<i>BE</i>	D3282	SHEET 1 OF 2
APPROVED	<i>qf</i>	TITLE	SCALE
DE APPR.	<i>ll</i>	WEB	NTS
DATE	11.05.05	COPYRIGHT © 2004 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE USA, INC.	



D3282-1 MACHINING NOTES

- 1 UNIFORM SECTION A-A
- 2 UNIFORM TAPER FROM SECTION A-A TO SECTION B-B
- 3 UNIFORM SECTION B-B
- 4 UNIFORM TAPER FROM SECTION B-B TO SECTION A-A
DRILL #30 (Ø0.128 REF) HOLES (57 PLACES) TO LINE UP WITH D3283-1,
SEE DETAIL D FOR REFERENCE
- 5 UNIFORM SECTION A-A
- 6 R1.00 BETWEEN SECTIONS



RELEASED
2011-09-12

DESIGN	CP	DART AEROSPACE USA, INC	
DRAWN	SC	PORT HADLOCK, WA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. D
MFG. APPR.	<i>[Signature]</i>	D3282	SHEET 2 OF 2
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	WEB	NTS
DATE	11.05.05	COPYRIGHT © 2004 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

DART AEROSPACE LTD		Work Order:	
Description: Float Web		Part Number:	D3282-041
Inspection Dwg: D3282 Rev: D		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
126.6	+/-0.100	126.562	✓		Tape	
1.500	+/-0.010	1.493	✓		Vernier	
3.000	+/-0.010	2.992	✓		Vernier	
6.000	+/-0.010	5.992	✓		Vernier	
1.250	+/-0.010	1.244	✓		Vernier	
30.000	+/-0.010	30.00	✓		Tape	
1.500	+/-0.010	1.494	✓		Vernier	
72.01	+/-0.030	72.00	✓		Tape	
61.75	+/-0.030	61.750	✓		Tape	
57.50	+/-0.030	57.50	✓		Tape	
49.19	+/-0.030	49.194	✓		Tape	
43.94	+/-0.030	43.925	✓		Tape	
39.69	+/-0.030	39.69	✓		Tape	
26.68	+/-0.030	26.70	✓		Tape	
0.55	+/-0.030	0.550	✓		Vernier	
1.970	+/-0.010	1.967	✓		Vernier	
2.38	+/-0.030	2.371	✓		Vernier	
0.05	+/-0.030	0.052	✓		high gage	

Measured by: <i>MM</i>	Audited by: <i>Truf</i>	Preliminary Approval:
Date: 2018/10/28	Date: 18/10/30	Date:

Rev	Date	Change	Revised by	Approved
A	07.04.02	New Issue	KJ/JLM	
B	12.02.01	Dwg Rev updated	KJ	

